

Work Order ID 52648

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Item ID:	D2617-5	Accept		Setup	Start	
Revision ID:	D2				Stop	
Item Name:	Spacer					
Start Date:	06/10/2009	Start Qty:	40.00			
Required Date:	13/10/2009	Req'd Qty:	40.00			
Reference:						

Approvals:	Process Plan:		Date:	09-10-5	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2617	Rev D2								

100		Hardinge CNC LATHE SMALL	0.00		100			
	Hardinge	Memo	0.00					
	Hardinge CNC Lathe Small	1-Machine as per Folio FA438 and Dwg D2617□2-Deburr						

110		QC2- Inspect parts off machine FAI/FAIB	0.00		100			
	QC	Memo	0.00					
	Quality Control							

120		QC8- Inspect parts - second check	0.00		102			
	QC	Memo	0.00					
	Quality Control							

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Item ID:	D2617-5	Accept		Setup	Start	
Revision ID:	D2				Stop	
Item Name:	Spacer					
Start Date:	06/10/2009	Start Qty:	40.00		Cust Item ID:	
Required Date:	13/10/2009	Req'd Qty:	40.00		Customer:	

Reference:

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00	UMD 09110116			X102			
140 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00	09-10-16			(102)			
150 Packaging Packaging	Identify as per dwg & Stock Location: 39 Memo	0.00 0.00				9/10/16	(102)		

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Item ID: D2617-5

Accept



Setup Start



Revision ID: D2

Stop



Item Name: Spacer

Start Date: 06/10/2009 Start Qty: 40.00



Cust Item ID:

Required Date: 13/10/2009 Req'd Qty: 40.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/10/19 *[Signature]*
MF
09-10-19

Picklist Print

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Parent Item: D2617-5RevD2



Parent Item Name: Spacer

Start Date: 06/10/2009

Required Date: 13/10/2009

Comments:

Start Qty: 40.00

Required Qty: 40.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6T0.500W.058		Purchased	No			100	f	439.0500	0.8211			
6061-T6 RD Tube .500 x.058W												

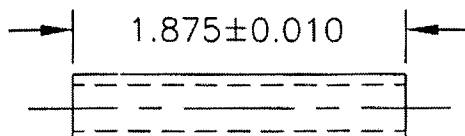
<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	439.05	
110335	0.6	
111757	11.61	
112652	126.84	
112800	300	

3.15 Lt SA 09/10/11

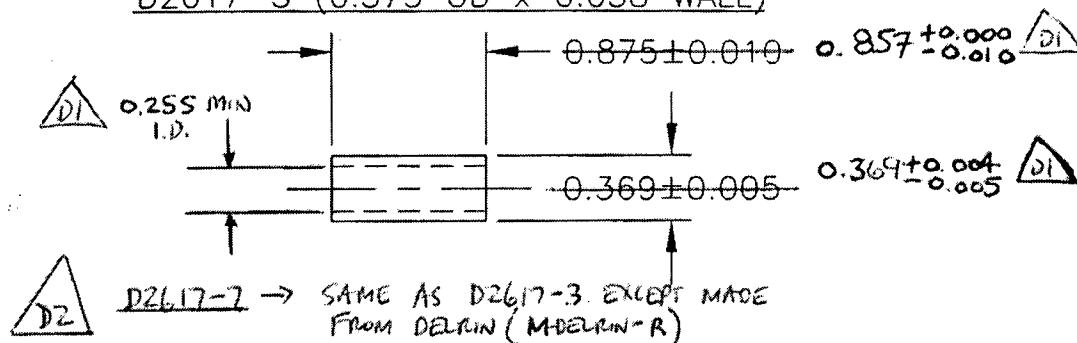


DESIGN	BW	DRAWN BY	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	#	APPROVED	#	DRAWING NO. D2617	REV. 0 SHEET 1 OF 1
DATE	01.07.04			TITLE BUSHING	SCALE 1:1
DZ	04.09.10	#	CP	ADD D2617-7	
A	96.10.08			NEW ISSUE	
B	97.05.08			.875 WAS 1.125	
C	97.06.04			0.369 DIA WAS 0.375	
D	01.07.04			ADD MAT'L SPEC AND TOL./DIM. NOTE	
D1	CP	#	04.07.12	CORRECT TOLERANCE (NCR 779)	

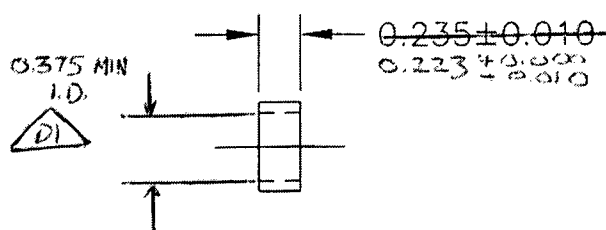
D2617-1 (0.375 OD x 0.058 WALL)



D2617-3 (0.375 OD x 0.058 WALL)



D2617-5 (0.500 OD x 0.058 WALL)



RELEASED
01.07.05

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 52448
3409-10-5

NOTES:

- 1) MATERIAL: 5052-H32 (QQ-A-225/7 OR WW-T-700/4)
OR 6061-T6 (QQ-A-225/8, QQ-A-200/8, OR WW-T-700/6)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) FINISH: ACID ETCH, ALODINE PER QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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